

Work Order ID 138328 - 2.

Tuesday, October 27, 2015 11:26:33 AM

138328

Page 1

Item ID: D4012-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Cushion

Start Date: 10/26/2015 Start Qty: 2400

24

Cust Item ID:

Required Date: 10/26/2015 Req'd Qty: 2400

24

Customer:

Reference:

Approvals:

Process Plan: MW

Date: 10-28

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4012	C

100

0.00

100

HAAS 1

HAAS CNC vertical machine #1

Memo

0.06

Mill as per folio FA889

Folio rev: 1A

Dwg. rev: C

24 48 15/12/21

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.00

24 15/12/22

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					

Root Cause		FAULT CATEGORY					
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :					
Misidentified ☐	Past Due ☐						

Work Order ID 138328

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138328

Page 2

Item ID: D4012-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Cushion

Start Date: 10/26/2015 Start Qty: 24.00

24

Cust Item ID:

Required Date: 10/26/2015 Req'd Qty: 24.00

24

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							
120						24	0		mlf 15/12/22
QC	Memo	0.01							
Quality Control									
130	Identify as per dwg & Stock Location: <u>S1545</u>	0.00							
130						24		8000 DEC 2 3 2015	
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.04							
Quality Control									

mlf DEC 2 3 2015

DQA: _____ Date: _____



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Misidentified ☐	Past Due ☐																																																														

Picklist Print

Tuesday, October 27, 2015 11:26:32 AM

Page 1

Work Order ID: 138328

138328

Parent Item: D4012-1

D4012-1

Parent Item Name: Cushion

Start Date: 10/26/2015

Required Date: 10/26/2015

Start Qty: 24.00

Required Qty: 24.00

Comments: IPP RevA: New issue 09.10.28 DD verified by:JLM
 revA as per dwg 09.11.18 DD verified by:JLM
 as per dwg Rev.B DD verified by:JLM
 IPP RevB:
 IPP Rev:C 11.01.10

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4287-3		Manufactured	No			100	f	37.4690	0.37	9.347368			

D4287-3

Uhmw U-Channel

Handwritten signature and date 10/26/15

Location

Loc Qty

Loc Code

ST479a

37.469

134273

15.74

137521

21.729

14132583

16.59

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

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								Lead hand / Supervisor Approval Verification	
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LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER: _____							
Misidentified ☐	Past Due ☐								

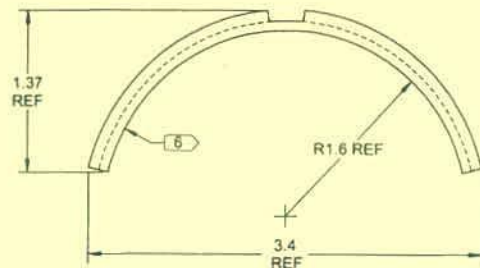
DQA: _____ Date: _____

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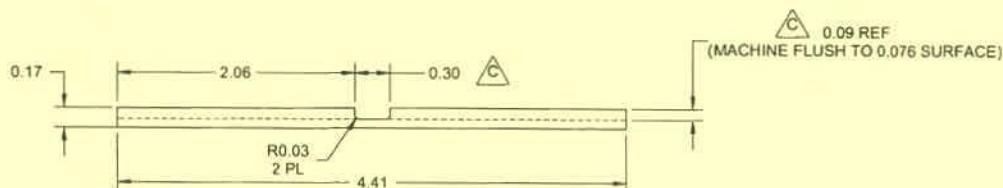
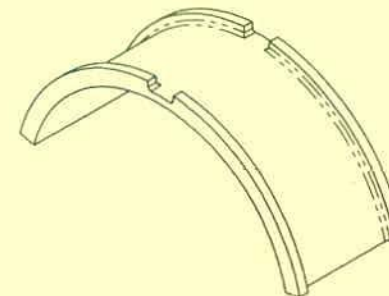
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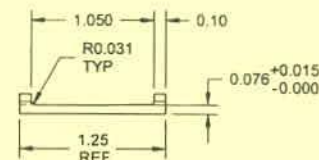


D4012-1 CUSHION
(MAKE FROM D4012 1F)
(COLD FORMED DURING INSTALLATION, DIMS REFERENCE ONLY)

138328 MLJ
151028



D4012-1F FLAT MACHINED STATE



- NOTES:**
1) MATERIAL: MAKE FROM D4287-3
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4012-1" AND B/N "BXXXXX" PER QSI 044 6.1
7) WEIGHT: 0.02 lbs

RELEASED

2015 MAR 26
ECW 15-532

C	ADD 0.30 NOTCH, 2 PL, ADD COLD FORM NOTE, REF DIMS FOR D4012-1. REASON: PAR 14-331, NCR 14-3521	DB	14.09.22
B	CHANGED RAW MATERIAL TO REDUCE MANUFACTURING COSTS; PART NOW MACHINED FLAT AND SHAPED WITH RADIUS. REF: PAR10-29	MB	10.12.07
A	NEW ISSUE	MB	09.10.19
REV.	DESCRIPTION	BY	DATE
DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	DD	D4012	SHEET 1 OF 1
APPROVED	HS	TITLE	SCALE
DE APPR.	HS	CUSHION	NTS
DATE	14.09.22	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPLICIT UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN AUTHORIZATION FROM DART AEROSPACE LTD.	

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WORK ORDER NON-CONFORMANCE / UPDATE

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